

ASAP

Date: Tuesday, 26/08/2008 7:28:44 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 41619		Part Number	: D33191	
Estimate Number	: 10437		Drawing Number	: D3319 REV. B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 26/08/2008	S.O. No. :	Drawing Revision	: B	
Frst Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 02/09/2008	
Previous Run	: 39564		Qty:	9	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	: Est: B 05.10.14 Added step 9, dwg rev B		KJ/EC		
	Est Rev:C Now on Waterjet 06-10-26 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048 
		9. Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s) 104921 x 6 = 4 1010/1025/A21/6aA SHEET .048 165084 x 7 = 5 Batch: <del>104921</del> HB 8-8-26
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B HB 8-8-26 Prog Rev: B (B)
	2-Deburr if necessary	HB 8-8-26
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  HB 8-8-26
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  S 08/08/26 (X/3)
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  N/A S Done at 08/08/26 12.2
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

08/08/08 09  
SR 08/09/08

(9)

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/08/08 (9)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod M10E762

EL 8-9-10

(x9)

9.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/10 (9)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/10 (9)

11.0 POWDER COATING POWDER COATING



M106L1Z

Barcode

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:20AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:50AM

INSPECT POWDER COAT/CHEMICAL CONVERSION

11 08-09-10 (9)

12.0 QC3



Comment: INSPECT POWDER COAT

Barcode

M-k

08/09/10 (9)

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Job Number: 41619

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(6)  
9x

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 496

8/9/10

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/11 JJ

Comment: FINAL INSPECTION/W/O RELEASE

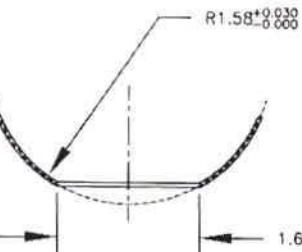
Job Completion



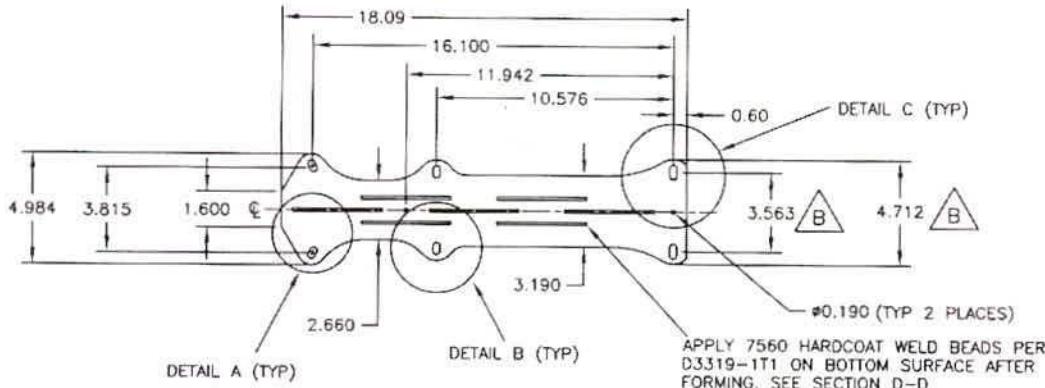
L 08/09/11

**DART**

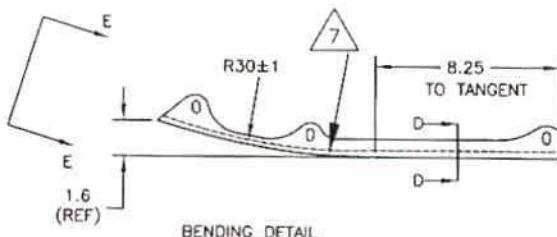
DESIGN	P1	DRAWN BY	DART AEROSPACE LTD	
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	05.06.06	REVISION	REV. B	
		TITLE	D3319	
		SCALE	SHEET 1 OF 5	
		SCALE	1:8	



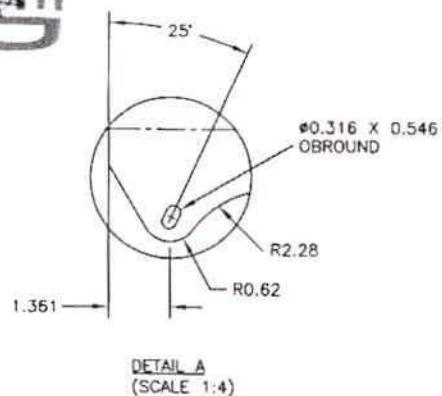
SECTION E-E (SCALE 1:2)



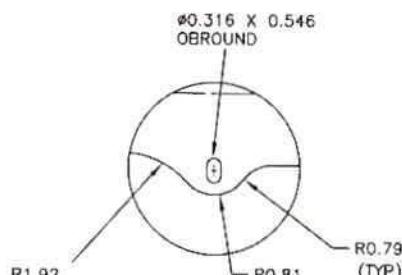
APPLY 7560 HARDCOAT WELD BEADS PER  
D3319-1T1 ON BOTTOM SURFACE AFTER  
FORMING, SEE SECTION D-D



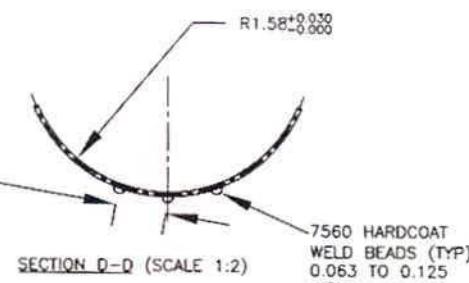
BENDING DETAIL



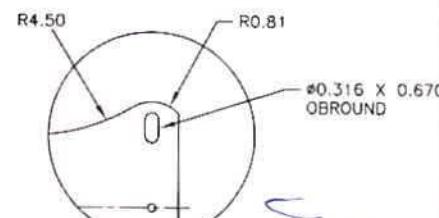
DETAIL A  
(SCALE 1:4)



DETAIL B  
(SCALE 1:4)



SECTION D-D (SCALE 1:2)



DETAIL C  
(SCALE 1:4)

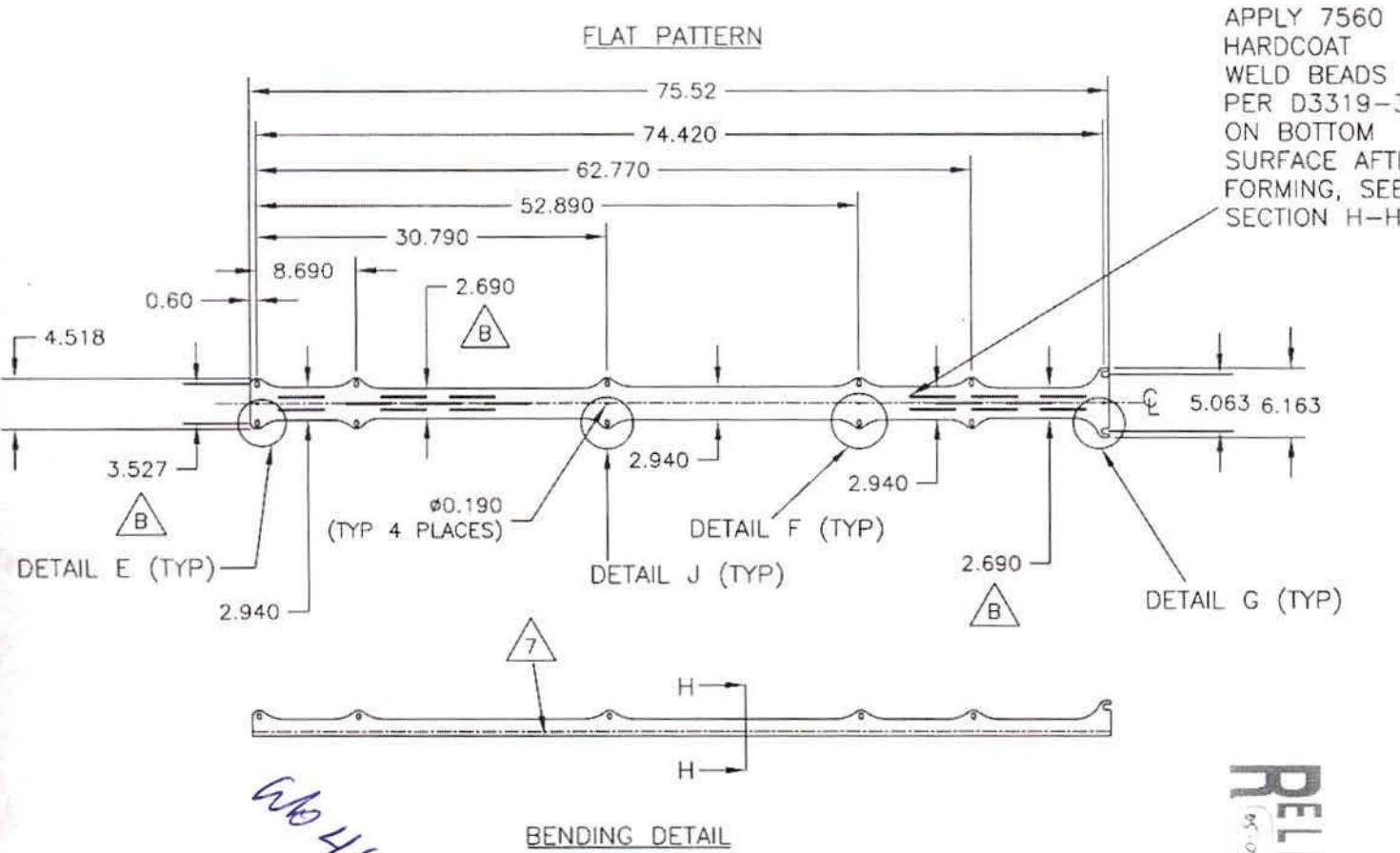
#### D3319-1 WEARPLATE

- 1) MATERIAL AISI 1010-1025 OR ASTM A36/A365/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**RELEASED**  
05.09.30 **#**

**DART**

DESIGN <i>AA</i>	DRAWN BY <i>PA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>AA</i>	APPROVED <i>PA</i>	DRAWING NO. D3319
DATE 05.06.06		SHEET 2 OF 5 TITLE WEARPLATE SCALE 1:15

**RELEASED**D3319-3 WEARPLATE

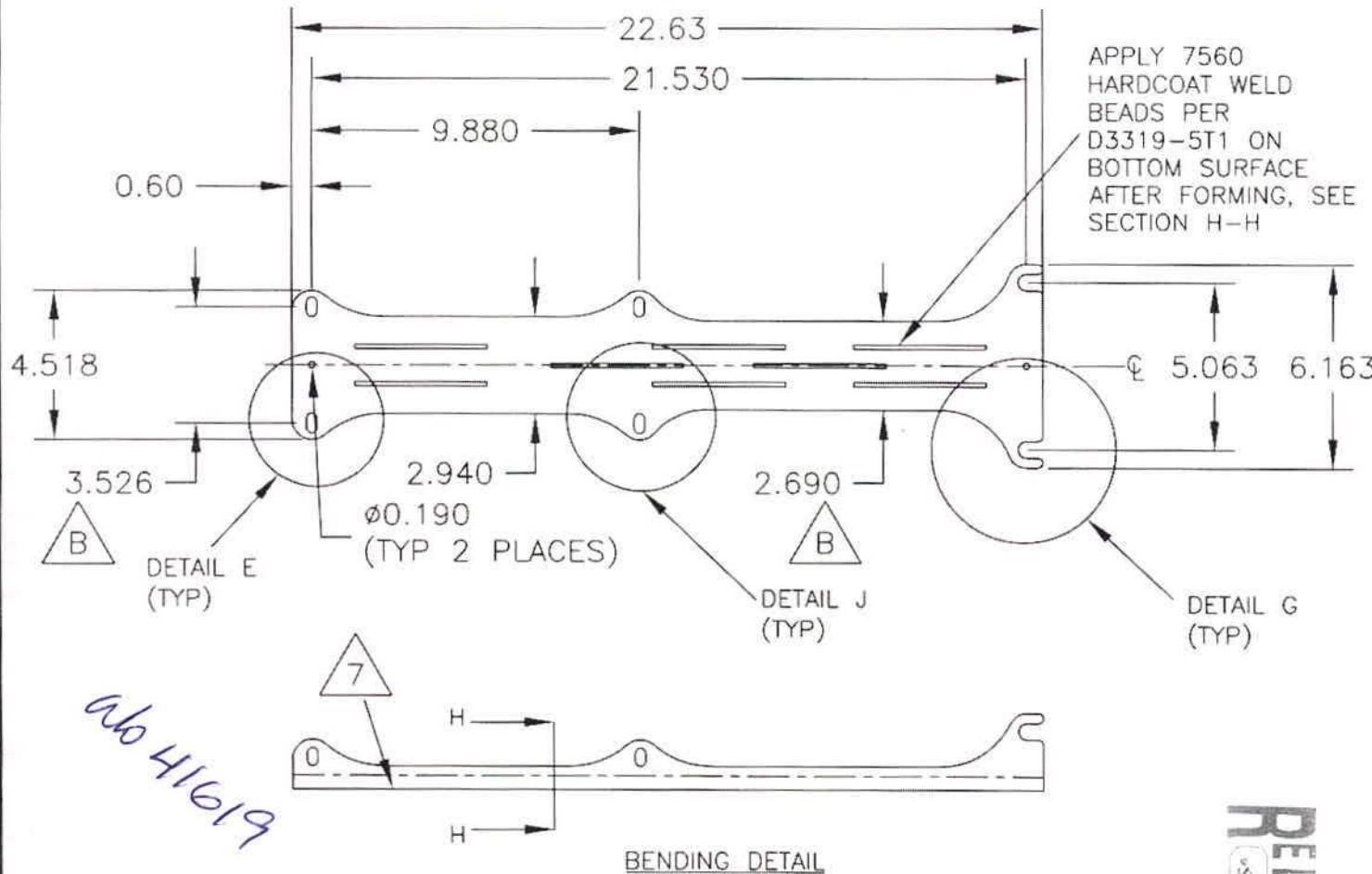
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DRAWN BY		DART AEROSPACE LTD	
DESIGN <u>P41</u>		HAWKESBURY, ONTARIO, CANADA	
CHECKED <u>JH</u>	APPROVED <u>JH</u>	DRAWING NO. D3319	REV. B
DATE 05.06.06	TITLE WEARPLATE		SHEET 3 OF 5
			SCALE 1:5

RE  
LEASED

## FLAT PATTERN

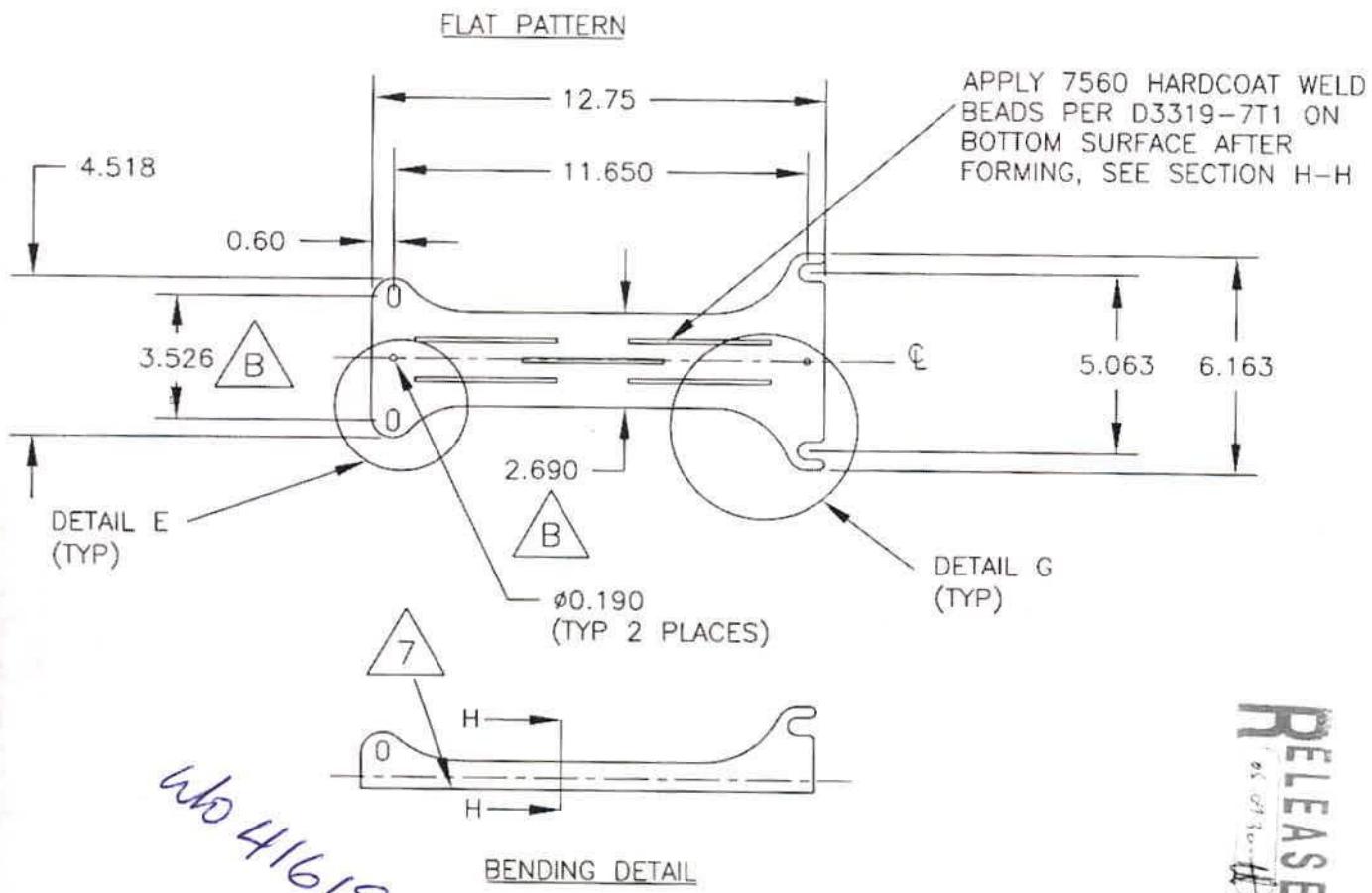


D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

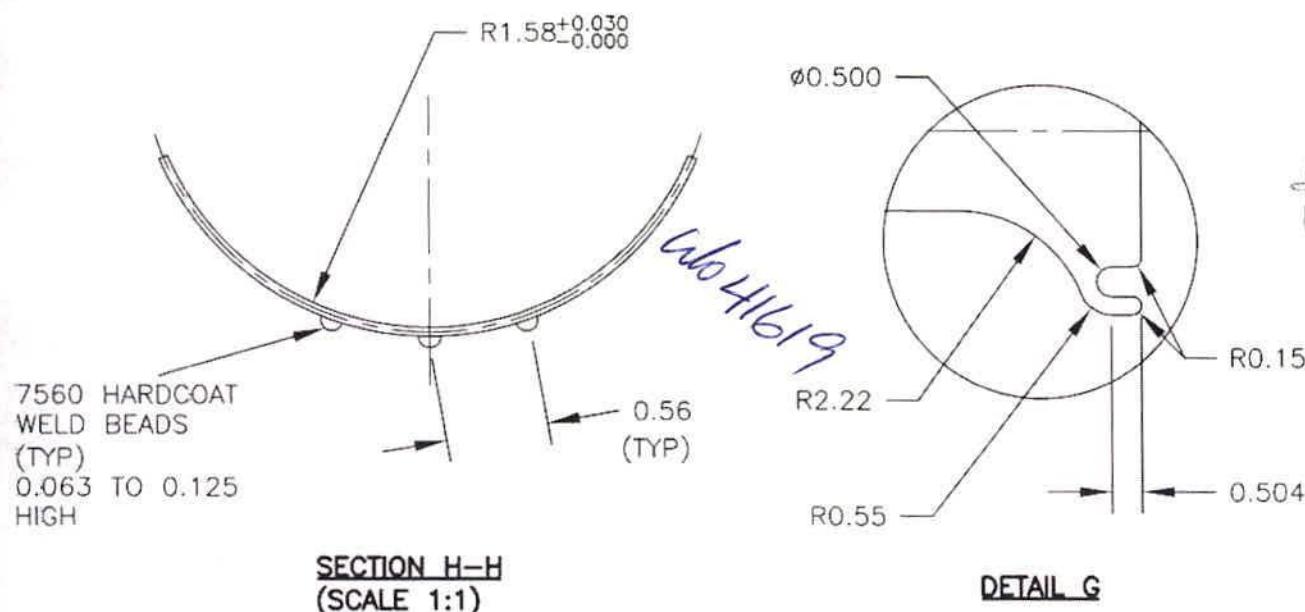
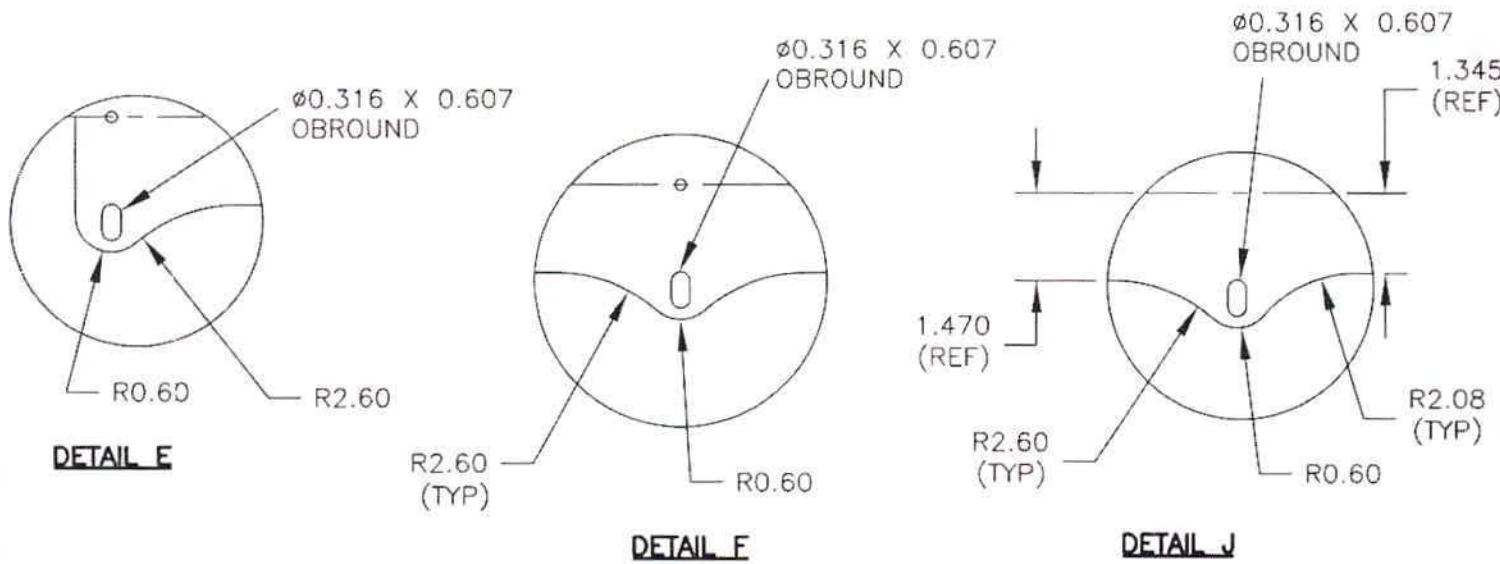
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 4 OF 5 SCALE 1:5

**RELEASED**D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SHEET 5 OF 5
SCALE 1:3		REV. B

**RELEASED**  
*CS 07 30 JH*

DART AEROSPACE LTD	Work Order:	41619
Description: WEAR PLATE	Part Number:	D3319-1
Inspection Dwg: D3319-1 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	<u>✓</u>
Date:	8-8-24	Date:	08/08/24	Date:	✓

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	